

Date: Thursday, 07/05/2009 3:30:36 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RADIUS BLOCK
Job Number : 47796	
Estimate Number : 10822	
P.O. Number :	Part Number : D2274
This Issue : 07/05/2009 S.O. No. :	Drawing Number : D2274 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 44547	Material :
Written By : _____	Due Date : 15/05/2009 Qty: 504 Um: Each
Checked & Approved By : _____	
Comment : Est. H 00.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00125	6061-T6 Bar .750 x .125
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Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s)
 6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M110591 JK 09/05/08

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Shear blanks 9.00" long +/- 0.030"
 Note: 1 blank makes 9 pieces

JK 09/05/08

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(504)

Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2274

M.A

09/05/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(504)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A

09/05/10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 09/05/11

504

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

09-5-19

Deburr any rough edges after tumbling

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD

09/05/19

(X531)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HK

09-05-19

(531)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 23

9/5/19

SV

(S31X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/19

Job Completion



MF

09-05-20

W/O:		WORK ORDER CHANGES					
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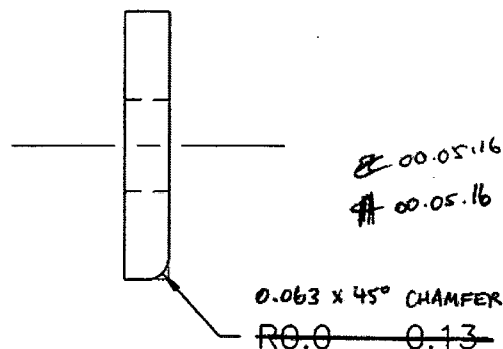
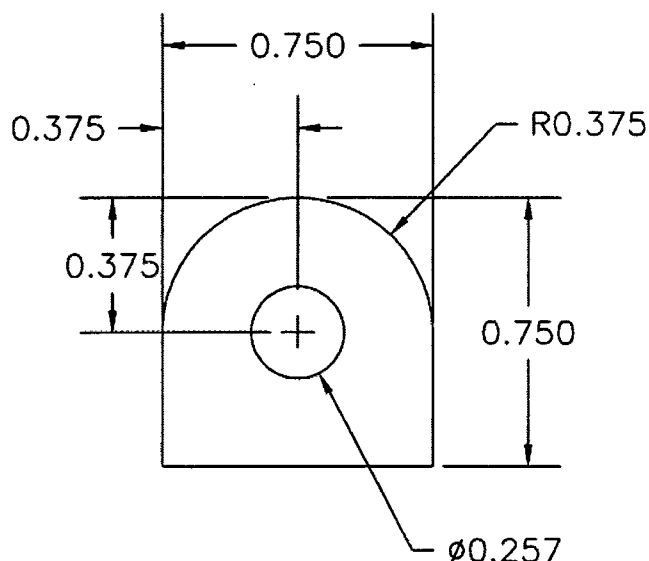
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>GA</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/13 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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